

Date: Thursday, 12/8/2005 2:35:15 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER
Job Number	: 25178		
Estimate Number	: 10628		
P.O. Number	:	Part Number	: D31381
This Issue	: 12/8/2005 S.O. No. : N/A	Drawing Number	: D3138 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 12/15/2005
Checked & Approved By	: SEE ABOVE DATE & USE	Qty:	7 Um: Each
Comment	: Est Rev: B 04.11.29 Made by Laser Cut KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O:

Email or Ship DXF file to vendor

Laser Cut D3138-1 flat pattern per Dwg D3138

Possible Supplier: GFI or Industrial Laser

Material release note is required

take from D3138-2 B24341
 (same flat pattern)

2.0	D31381F	Cover
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Comment: Qty.: 1.0000 U(s)/Unit Total : 7.0000 U(s)
 Cover

⑦

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

N/A

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

N/A

5.0	A SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

Bend as per Dwg D3138

JP 05/12/12 7

5.0b Inspect Level 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05.12.13	5.	Change made as shown permanent change					 05-12-13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Yes Date: 06/03/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: COVER

Job Number: 25178

Part Number: D31381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a-m

06-03-21

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M DL 06/03/21 (7)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M DL 06/03/22 (7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock with part number and batch number using fine point permanent ink marker as per view
B-B top surface Dwg D3138

5787

DL 06/03/22 (7)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/03/22 (7)

Job Completion



DL 06-03-23

5/42

DART AEROSPACE LTD		Work Order:	24341
Description: Cover		Part Number:	D3138-2
Dwg: D3138 Rev. B ID		Qty:	A 10 2
PF 05 12 05 P52 051 042		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.09.26	A10
2	PG	Issue P/O: <u>2008728</u> Email or Ship DXF file to vendor Laser Cut D3138-2 flat pattern per Dwg D3138 Possible Supplier: GFI or Industrial Laser Material release note is required	AL	05/09/27	10
3	RG	Receive and Inspect for transit damage Enure material release note is attached	CL	05/11/18	10
4	QC6	Inspect dimensions as per Dwg D3138	J	05-11-28	10
5	GA	Deburr	DL	05/12/05	10
6	GA	Bend as per Dwg D3138	JB	05/12/05	10
7	QC5	Inspect work to Step 6			
8	FP	Chemical Conversion Coat per QSI 005 4.1			
9	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) per QSI 005 4.3			
10	QC3	Inspect Powder Coat			
11	ST	Identify and Stock with part number and batch number using fine point permanent ink marker as per view B-B top surface Dwg D3138			
12	AC	Cost / part: _____			
13	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	02.05.24	New issue	NG	
B	04.11.29	Made by Laser Cut	KJ/RF	

RELEASED
2004/11/30

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: 10 MAI 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0058764

de commande SSMQ: 841339

Customer's order #:

SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
7	1	.032" x 48" x 144"	2024 T3	AMS-QQ-A-250/4	226511

Bien à vous,
Yours truly,



Commis à l'administration.
Administration Clerk.



SHIP TO: LES METAUX SPECIALISES SAMUEL (SHIP TO) 21525 CLARK GRAHAM BAIE D'URFE, PQ, CA H9X3T5	
SOLD TO: SAMUEL SON & CO LTD 2225 FRANCIS HUGHES LAVAL, PQ, CA H7S1N5	
CUSTOMER PO NUMBER: N16221	CUSTOMER PART NUMBER:
KAISER ORDER NO: 1008983	LINE ITEM: 1
WEIGHT SHIPPED: 3928 LB	QUANTITY: 173 PCS EST.
SHIP DATE: 9-JUL-2004	B/L NUMBER: 202031
SHIPPING RUN #/LOAD ID: 100089/2	GOV'T CONTRACT NUMBER:
ALLOY: 2024	CLAD: BARE
GAUGE: 0.0320 IN	WIDTH: 48.00 IN
TEMPER: T3	LENGTH: 144.000 IN

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4011938

Certified Specifications

AMS 4037/RevN

AMS-QQ-A-250/4/RevA

ASTM B 209/Rev04

Test Code: 1504

Test Results

Lot: 226511 Cast

Drop

Ingot

Tensile:	Temper	Dir / # Tests		Ultimate KSI (MPA)			Yield KSI (MPA)		Elongation %			
	T3	LT / 2 (Min:Max)		67.4 : 67.6 (465 : 466)			45.2 : 45.3 (312 : 312)		17.8 : 18.3			
Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	
Actual	0.08	0.22	4.46	0.55	1.32	0.01	0.17	0.01	0.01	0.00	TOT	0.06

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772 (MIL-H-6088). ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR